: CABLE GUARD

: D29163

: N/A

:NIA

: 10/08/2006

D2916 REV B

Friday, 14/07/2006 2:45:56 PM -

User:

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 27905 : 12457

Estimate Number P.O. Number

: NIA

This Issue

: 14/07/2006

: NC

Prsht Rev. First Issue **Previous Run**

Written By

: 13/07/2006

: MACHINED PARTS

Checked & Approved By Comment

: Est Rev:A New Issue 06-06-19 JLM

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

2.0

MUHMWB10

UHMW 1" Black



Comment: Qty.:

0.5500 sf(s)/Unit

Total: UHMW 1" Black

5.5000 sf(s) 101259

10

10 Um:

Each

3.0 QC2

SAN

4.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

16

5.0

HAAS1

Comment: SECOND CHECK

HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

BATCH: M101253

2-Deburr per dwg D2916

gm/ 06/08/15

15

Date: User: Seq. #:

Friday, 14/07/2006 2:45:57 PM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 27905

Part Number: D29163

Job Number:



Machine Or Operation:

Description:

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

PARTS AS THEY COME OFF MACHINE Comment: INSPECT

7.0

SECOND CHECK



Comment: SECOND CHECK

PACKAGING RESOURCE #1



8.0

PACKAGING 1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

10

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL Inspection Level 21

Job Completion



Thursday, 7/13/2006 3:38:17 PM Kim Johnston User: **Process Sheet Drawing Name** : CABLE GUARD : CU-DAR001 Dart Helicopters Services Customer Job Number : 27905 : 12457 **Estimate Number** : D29163 Part Number P.O. Number · D2916 REV B This Issue : 7/13/2006 S.O. No. : **Drawing Number** : N/A : NC Project Number Prsht Rev. : MACHINED PARTS : // : B First Issue Type Drawing Revision Previous Run Material : 8/10/2006 Qty: 10 Um: Each Due Date Written By Checked & Approved By : Est Rev:A New Issue 06-06-19 Comment **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: **PURCHASING** PG 1.0 Cut on water get

10) MUHMWS10 Comment: PURCHASING Issue P/O: For (1) D2916-3 44.94" x 1.75" x 1.00" (Tolerance for all measurements is (+0.030/-0.000) Material: Black UHMW(MUHMWB10) Possible Supplier: GE PolymersMaterial release note is required PACKAGING RESOURCE #1 20 PACKAGING 1 3.0 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached DIMENSIONAL CHECK 2.0 Comment: DIMENSIONAL CHECK 4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 BATCH:_____

1- Mill as per Folio FA2916-3 Rev: _____ & Dwg D2916 Rev: ____

2-Deburr per dwg D2916

Page 1

Form: rorocess

Dart A	erospac	e Lta						
W/O:		<u> </u>	W	ORK ORDER CHANGES	···			
DATE	STEP	PRO	ANGE	Ву	Date Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
•								
- !								
NCR:		V	VORK ORE	DER NON-CONFORMANCE	(NCR)		i
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	DATE STEP Description of NC Section A			Action Description Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector
	1 4		1			1	1	1

NCR:		\	WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval	Ammunual					
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector				
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Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	I/C CI	osed:	Date:

Date: User:

Thursday, 7/13/2006 3:38:17 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 27905

Part Number: D29163

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK





Comment: SECOND CHECK

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector			
				:						
1 1 1										
						<u>'</u>				

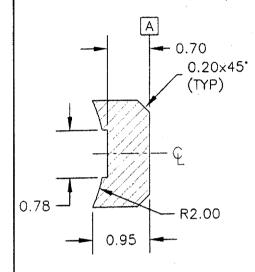
NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	····· ·	Verification		Approval				
DATE	STEP	Section A			Sign & Date	Section C	Approval Design Mgr	Approval QC inspector				
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Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA: _	 Date:	
NOTE: Date & initial all entries	,			QA: N	/C CI	osed:	 Date:	

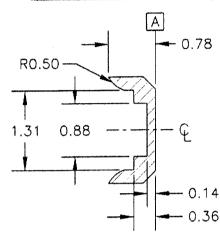




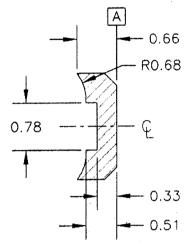
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B
#	#	D2916 SHEET 1 OF 2
DATE		TITLE SCALE
00.02.24		CABLE GUARD 1:6
А	99.09.29	NEW ISSUE
В	00.02.24	ADD K-K FOR D2521 COMPATIBILITY



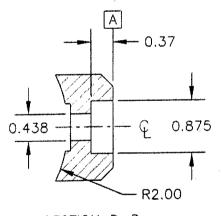
SECTION A-A (SCALE 2:3)



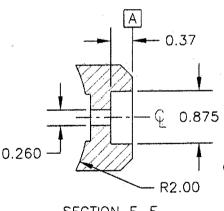
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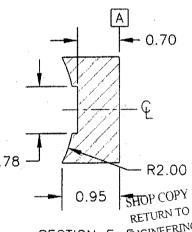
SECTION C-C (SCALE 2:3)



SECTION D-D (SCALE 2:3)



SECTION E-E (SCALE 2:3)



SECTION F - ENGINEERING

UNCONTROLLED COPY

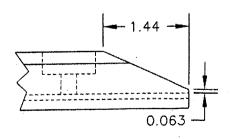
SUBJECT TO AMENDMENT

SUBJECT TO SUBJECT TO AMENDMENT

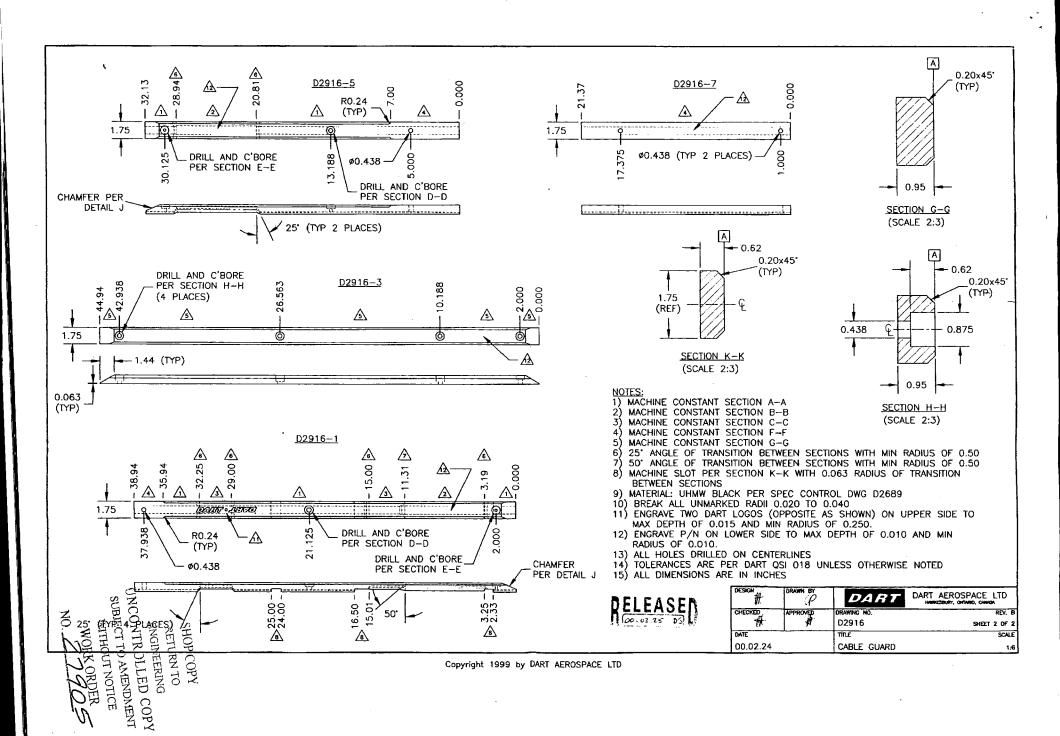
SUBJECT TO SUBJECT TO

SUBJECT TO ANICHE WITHOUT NOTICE WORK ORDER





DETAIL J (SCALE 2:3)



DART AFROSRACE LTD	Work Order: 2790
DART AEROSPACE LTD	
, 4	Part Number: D2916-
Description:	
Paris	Page 1 of
Inspection Dwg: Rev:	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1,75	± 0.030	1.756	V		Vern Measurington Vern	
44.94	±0.030	44.925			Vern	
1.00	\$ 0.030/-0.000	1,20			Vern	
0.95	±.030	0.947			•	
0.20×45°	±.030	0.195745				
0.626	±.030	0.614				
0.875	±. 010	0.872				
00.438	+.006	60.437				
2.000	±.010	2.000				
4	4000	传三帝				
1. 44	±-03b	1.450				
0.063	±.010	0.063				
,						
	· • · .					
		<u> </u>				

			10/10	1.	11/1
Measured by: 5AD/9m2	Audited by:	ゴ.6	/ pb/60	totype Approval:	MA
	Date:	06/08/10		Date:	
Date: 66 5 08:10		7			

Dave	Date	Change	Revised by	Approved
Rev	Date	New Issue	KJ/JLM	
A	<u></u>	New 19300		